

Work Order ID 109667

November-25-13 10:14:20 AM

\*109667\*

Page 1

Item ID: D4095-041 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID:  
Item Name: Wearplate Assembly Stop \*NS2\*  
Start Date: 11/25/13 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 12/09/13 Req'd Qty: 10.00 \*10\* Customer:

Reference: \*NR1\* \*NR2\*  
Approvals: Process Plan: MJS Date: 13-11-25 Tooling: Date: Run Start Stop  
QC: Date: SPC (Y/N): Date:

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Item ID:	D4095-041	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Wearplate Assembly						
Start Date:	11/25/13	Start Qty:	10.00	*10*	Cust Item ID:		
Required Date:	12/09/13	Req'd Qty:	10.00	*10*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00		DAS 30 9-89		10			13/11/26
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00	SMR B11127			10			
150 <b>*150*</b> Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M127456</u> Large Fab Memo	0.00				10			13-12-06 M.A.C.

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Revision ID:  
Item Name: Wearplate Assembly Stop \*NS2\*  
Start Date: 11/25/13 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 12/09/13 Req'd Qty: 10.00 \*10\* Customer:

Reference: \_\_\_\_\_ Run Start \*NR1\*  
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  <b>Memo</b>	0.00 0.00						10	DAS 9 9-89
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  <b>Memo</b>	0.00 0.00						10	DAS 9 9-89
180 <b>*180*</b> HandFinish Hand Finishing	  <b>Memo</b> COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 125335	0.00 0.00				10	0	0	AF 13-12-12

Work Order ID 109667

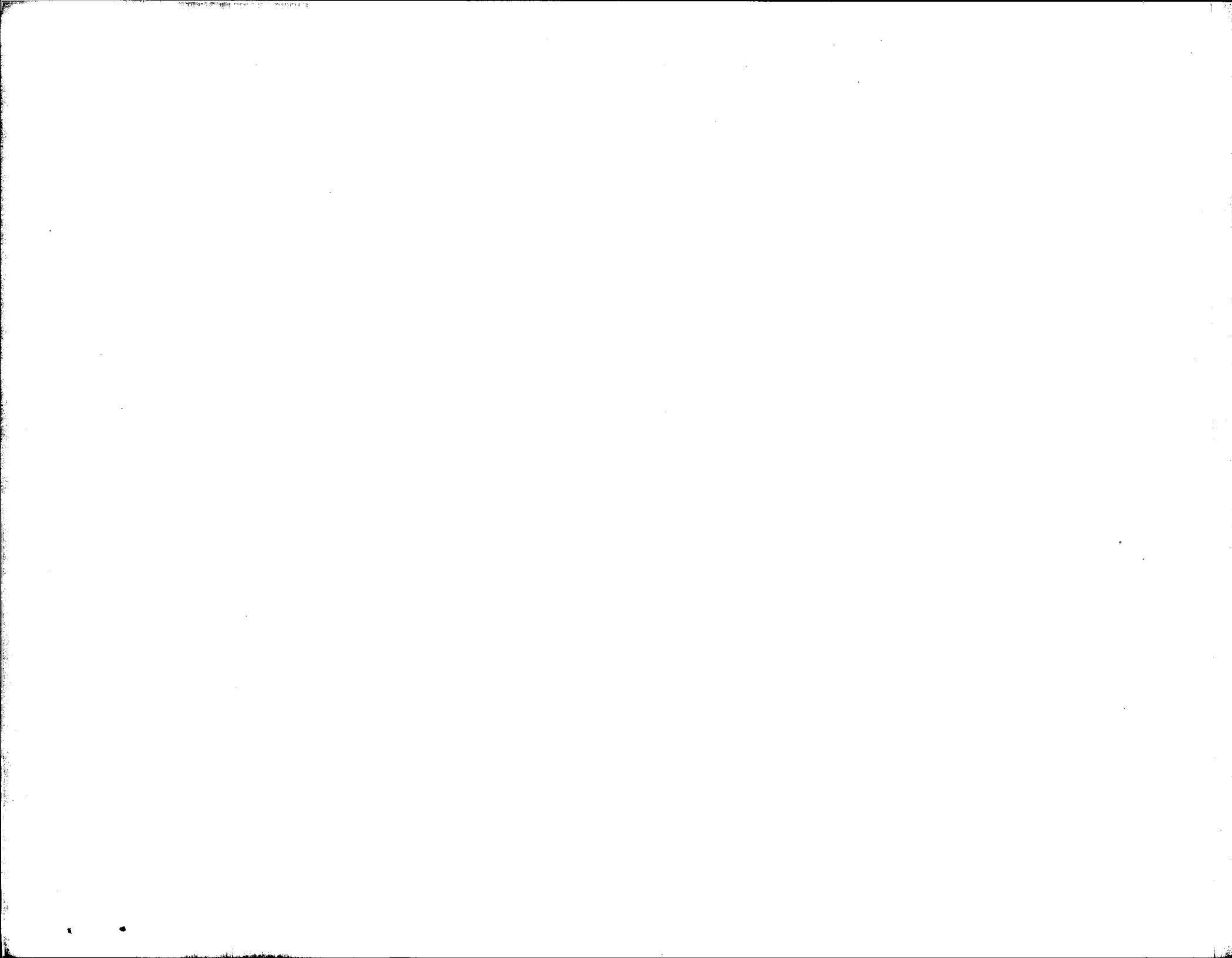
November-25-13 10:14:20 AM

\*109667\*

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Item ID:	D4095-041		Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop		*NS2*
Item Name:	Wearplate Assembly						
Start Date:	11/25/13	Start Qty:	10.00	*10*	Cust Item ID:		
Required Date:	12/09/13	Req'd Qty:	10.00	*10*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish Memo	0.00				10			05 13-12-11
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: F3-007 Memo	0.00				x10	d	ll vs/n/11	
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							D/R 13-12-11 MB 12-11



# Picklist Print

Page 1

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Work Order ID: 109667

\*109667\*  
\*D4095-041\*

Parent Item: D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 11/25/13

Required Date: 12/09/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	352.2540	2.275	24	**		

\*M304S16GA\*

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	352.2539998	
123136	140.2	
M126159	26.22	
M126915	185.834	126915

Jm.3-11-25

DART AEROSPACE LTD	Work Order:	109667
Description: Wearplate	Part Number:	D4095-1
Inspection Dwg: D4095	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	—		✓	Jkmor
0.300	+/-0.010	0.302"	—		✓	
0.300	+/-0.010	0.303"	—		✓	
2.432	+/-0.010	2.437"	—		✓	
3.227	+/-0.010	3.230"	—		✓	
4.06	+/-0.030	4.065"	—		✓	
4.98	+/-0.030	4.98"	—		✓	
8.43	+/-0.030	8.43"	—		✓	Prod 023
9.22	+/-0.030	9.22"	—		✓	
3.500	+/-0.010	3.500"	—		✓	
24.750	+/-0.010	24.750"	—		—	Jkmor
11.50	+/-0.030	11.50"	—		✓	
11.472	+/-0.010	11.472"	—		✓	
6.000	+/-0.010	6.004"	—		✓	
12.104	+/-0.010	12.104"	—		—	
18.000	+/-0.010	18.000"	—		✓	
30.000	+/-0.010	30.000"	—		—	
9.00	+/-0.030	9.006"	—		✓	
36.000	+/-0.010	36.000"	—		—	
38.87	+/-0.030	38.87"	—		—	
2.50	+/-0.030	2.50"	—		✓	
0.063	+/-0.010	0.059"	—		✓	

DAS

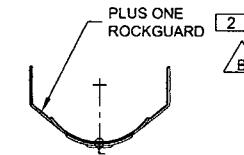
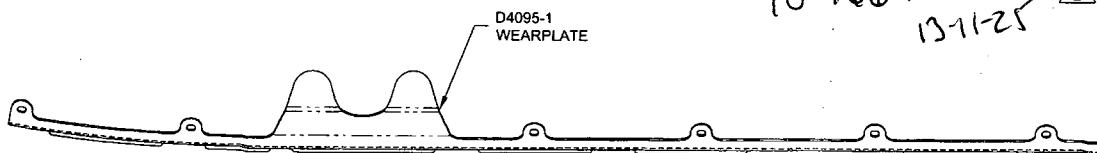
Measured by:	Jm	Audited by:	27 9.89	Preliminary Approval:	
Date:	13-11-25	Date:	13/11/06	Date:	

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	M

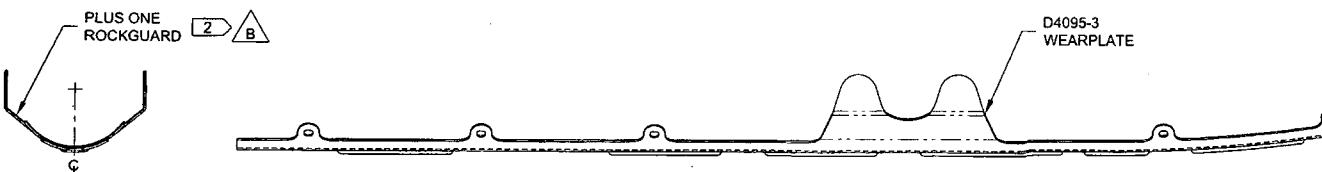
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

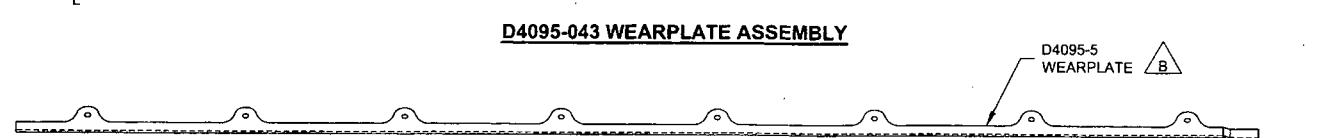
109667 MLC  
13-11-25



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

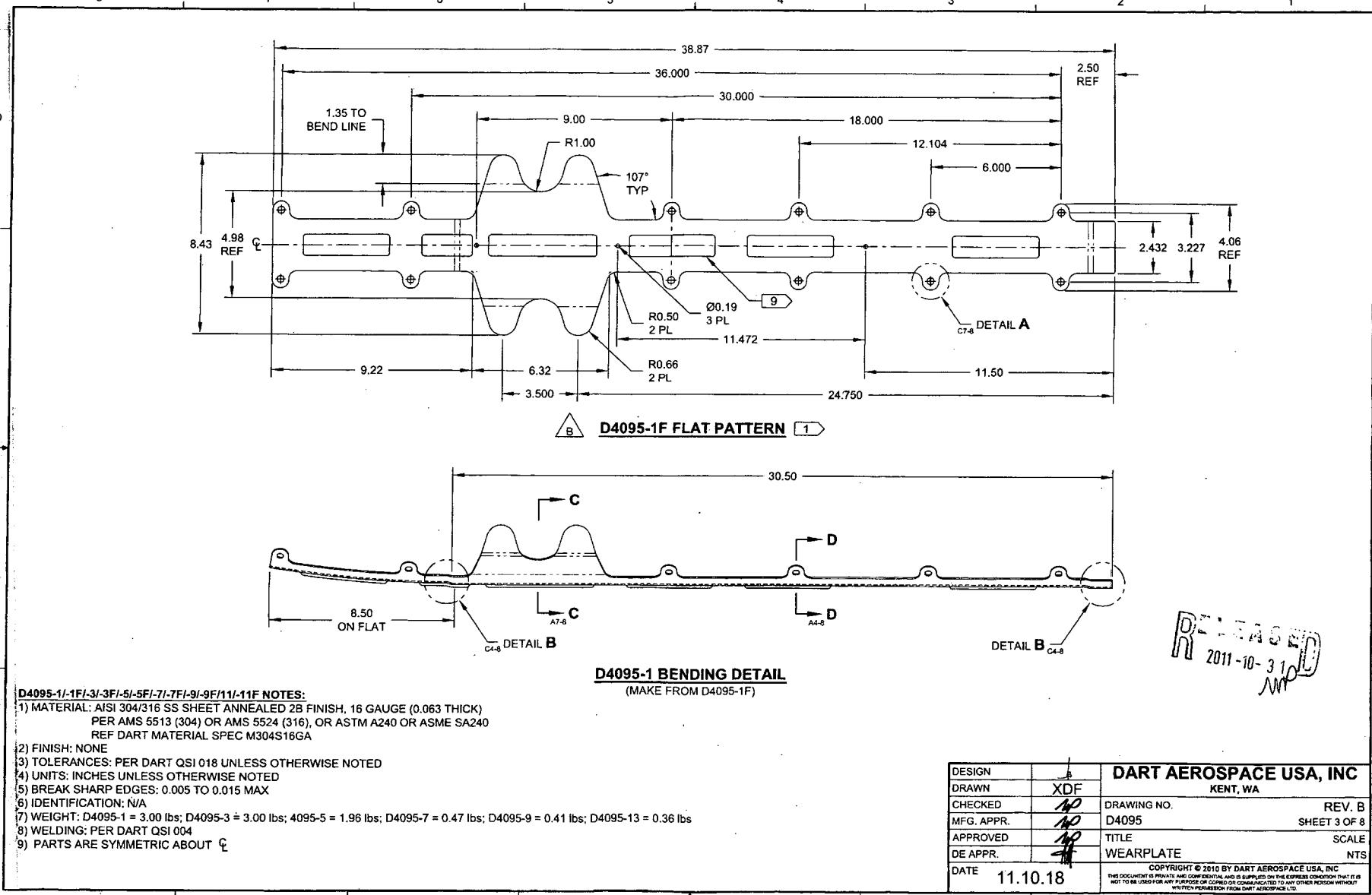
**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT  $\frac{C}{2}$



B	REVISED D4095-1-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7-9/11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	XDF		
CHECKED	<i>10</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>10</i>	D4095	SHEET 1 OF 8
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



8

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6

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2

1

D

D

C

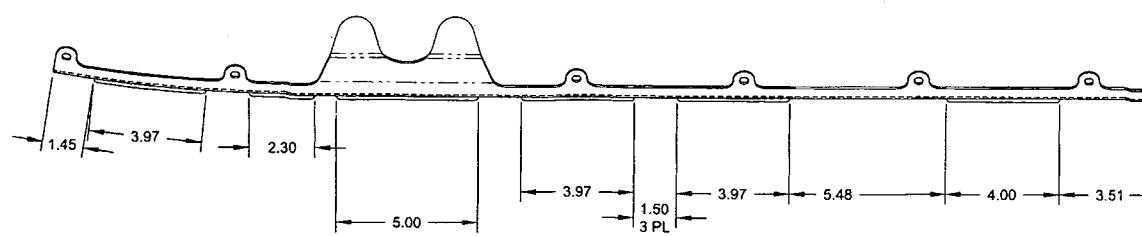
C

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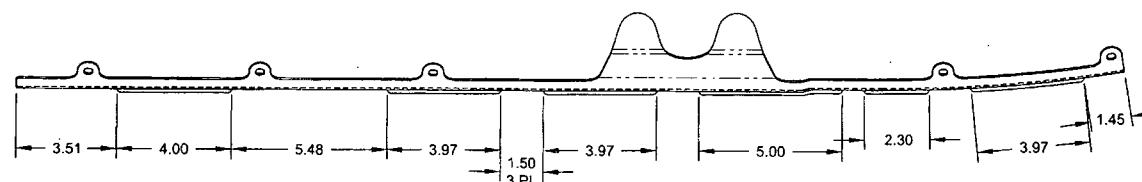
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A

A



D4095-1 WELDING DETAIL 

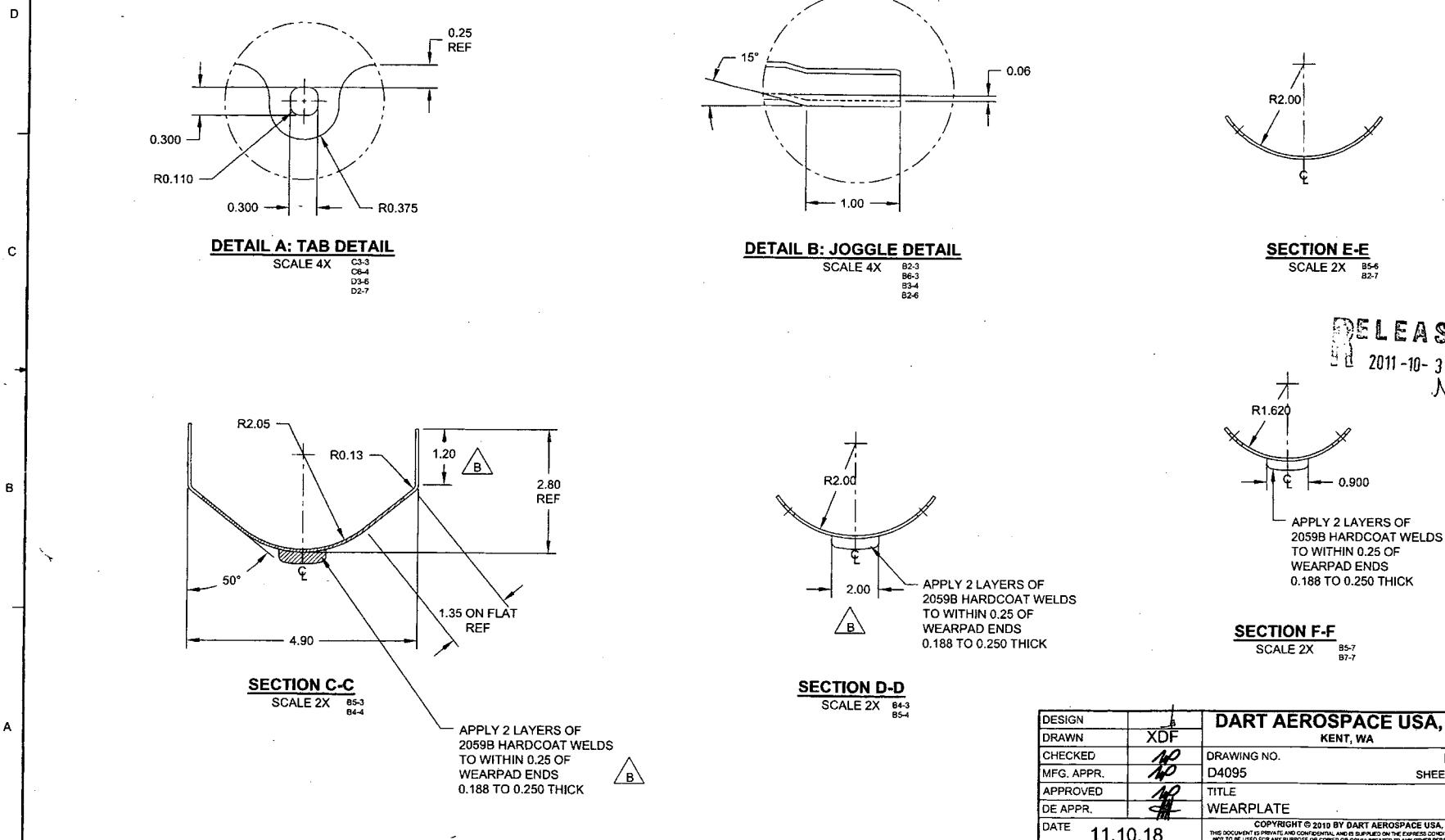


D4095-3 WELDING DETAIL 

RELEASED  
2011-10-31  
M

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4095	SHEET 5 OF 8
APPROVED		TITLE	SCALE
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DESIGN	B	DART AEROSPACE USA, INC
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CHECKED	10	DRAWING NO. REV. B
MFG. APPR.	10	D4095 SHEET 8 OF 8
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DE APPR.	10	WEARPLATE NTS
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